

Date: Wednesday, 17/09/2008 10:38:06 AM
User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HINGE
Job Number : 42052
Estimate Number : 13565
P.O. Number :
This Issue : 17/09/2008 S.O. No. :
Prsht Rev. : NC Part Number : D38131
First Issue : // Type : MACHINED PARTS Drawing Number : D3813 PREL
Previous Run : Material :
Written By : JLM 08.09.17 Due Date : 24/09/2008 Qty: 3 Um: Each
Checked & Approved By :
Comment : Est Rev:A New Issue 08-09-03 JLM Verified By:EC

Additional Product

~~PRELIMINARY ISSUE~~

Job Number:



FOR ENGINEER'S USE ONLY

Seq. #. Machine Or Operation: Description :

1.0 M6061T6B2500X03500 6061-T6 Bar 2.50 x 3.50



Comment: Qty.: 0.2671 f(s)/Unit -Total: 0.8014 f(s)

6061-T6 Bar 2.500" x 3.00" 3.500"

BATCH: M105202

DIP 08/10/02



2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blank 3.050" * long

DIP 08/10/02



3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA779 Rev. AA & Dwg D3813 Rev. A

2-Deburr per dwg D3813

3-Finish tapping hole to final depth as per Dwg D3813

mf 08/10/03



4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mf 08/10/03



5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

M.A 08/10/03



Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE

Job Number: 42052

Part Number: D38131

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(47)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 08/10/06

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

MASK THREADED HOLE PRIOR TO POWDER COAT

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

N/A w per DandS

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

give to handz/any

Harvey

SS 08/10/06 (x4)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

EFFECTIVE

AUTH

PAGE

DATE

w 08/10/06

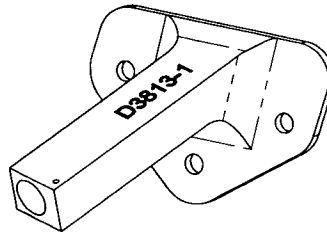
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C

C

INARY ISSUE

B

B

NOTES:

- 1) MATERIAL: 6061-T6 (C
PER AMS-
2) FINISH: CHEMICAL CO
POWDER COA
3) TOLERANCES: PER D
4) UNITS: INCHES UNLES
5) BREAK SHARP EDGES
6) IDENTIFICATION: N/A
7) WEIGHT: 0.14 lbs
8) MASK HOLE PRIOR TO

11

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D3813

REV. A

SHEET 2 OF 4

TITLE

HINGE

SCALE

NTS

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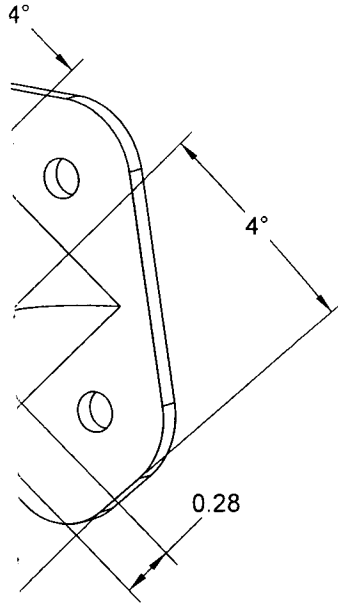
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PRELIMINARY ISSUE

A

A

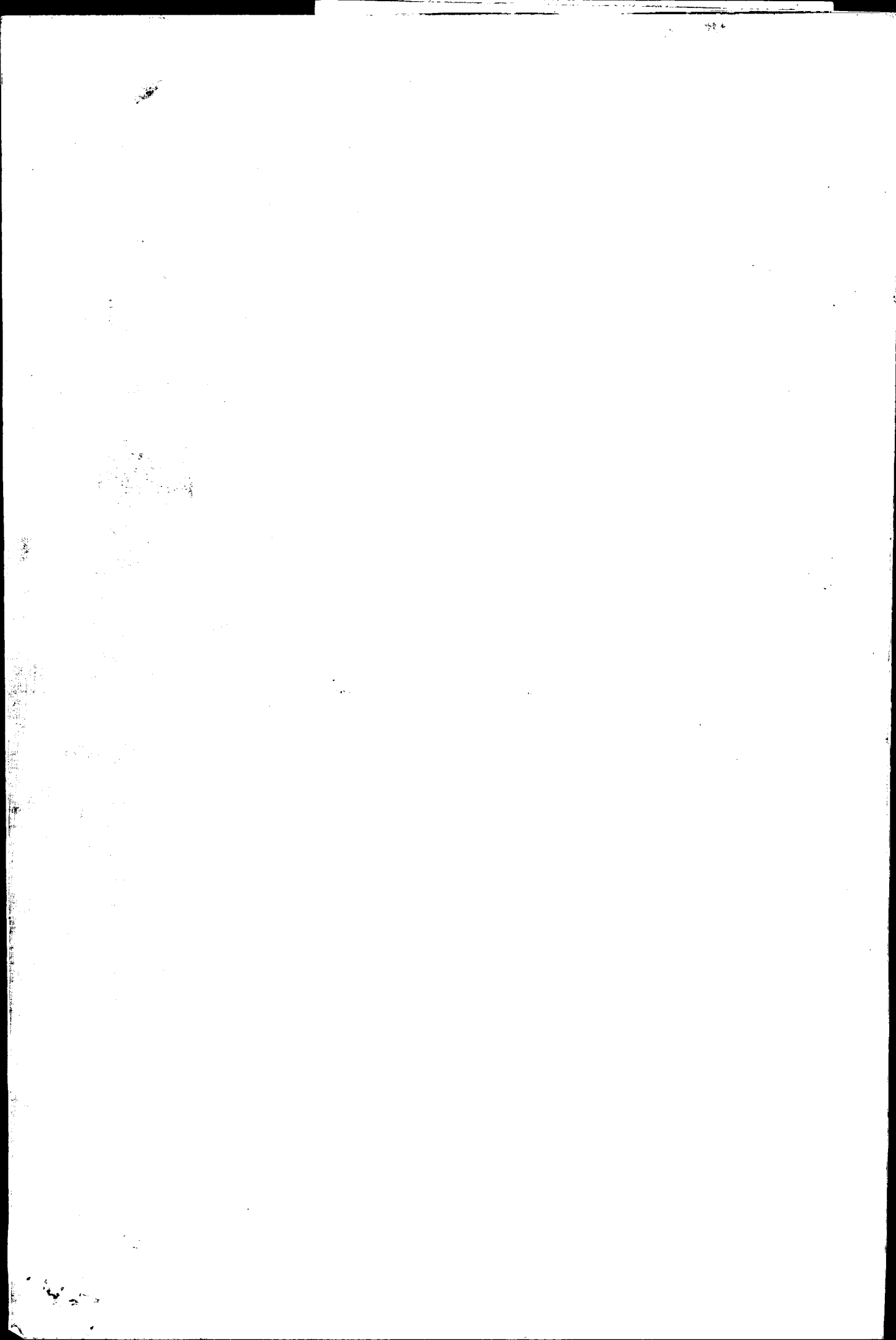
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3813	REV. A SHEET 3 OF 4
TITLE HINGE	SCALE NTS
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DART AEROSPACE LTD		Work Order: 42052
Description: HINGE		Part Number: 03813-1
Inspection Dwg: 03813 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.125	±.010	.121	✓			
1.55	±.030	1.550	✓			
.90	±.030	.902	✓			
2.89	±.030	2.910	✓			
.70	±.030	.700	✓			
R.044	±.030	R.440	✓			
Ø.219	±.005 ±.001	Ø.220	✓			
.56	±.030	.551	✓			
62°	±.12°	62°	✓			
.69	±.030	.682	✓			
.090	±.030	.092	✓			
.13	±.030	.124	✓			
Ø.060	±.004 ±.001	Ø.064	✓			
.28	±.030	.276	✓			
.28	±.030	.284	✓			
Ø.391	±.006 ±.001	Ø.392	✓			
1.25	±.030	1.245	✓			

Measured by:	<i>mf</i>
Date:	08/10/03

Audited by:	
Date:	

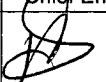



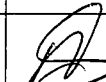

Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

W/O: _____		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/10/03	3	1 part scrap. the dim. .56 to small of .030" and dim .690 to small of .030" 1 part scrap the holder touch the part and make a mark	 	scrap it and destroy replace Qty: 2 Batch: <u>17105242</u>	 08/10/03	 08/10/03	 again	 08/10/03

NOTE: Date & initial all entries